Dart Aerospace Ltd. Thursday, 7/13/2006 3:38:09 PM Date: Kim Johnston User: **Process Sheet** Customer : CU-DAR001 Dart Helicopters Services **Drawing Name** : TUBE Job Number : 27900 **Estimate Number** : 11172 : D22827 A)U: Part Number P.O. Number S.O. No. : N/A . D2282 REV E This Issue : 7/13/2006 **Drawing Number** Project Number : N/A Prsht Rev. : NIA : MACHINED PARTS : E Type First Issue **Drawing Revision** : 26817 :NA Material **Previous Run** : 8/15/2006 200 Um: **Due Date** Qty: Written By Checked & Approved By 05-12-02 JLM Comment : Est Rev:Á Removed from 9 Digit **Additional Product** Job Number: Description: **Machine Or Operation:** Seq. #: M304TR0675W091 304 RD Tube .675 x .091W 1.0 Comment: Qty.: 0.0699 f(s)/Unit Total: 13.9860 f(s) Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness (M304TR0.675W.091) 13.986 F. HARDINGE CNC LATHE SMALL 2.0 Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Dwg D2282 and Folio FA190 1/0.09.07 2-Deburr 3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8

Comment: SECOND CHECK PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock Location:





5.0

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Dart Aerospace Ltd

W/O:		WORK ORDER CH	HANGES						
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
	Description of NC		Corrective Action Section B		Verification	A	
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NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Date:

Thursday, 7/13/2006 3:38:10 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 27900

Part Number: D22827

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

DOCUMENT CONTROL





Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



D 06/09/07 U No.0907

Dart Aerospace Ltd

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Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:
NOTE: Date & initial all entries				QA: N	I/C C	losed:	Date:

DART AEROSPACE LTD	Work Order:	27900
Description: Handle Tube	Part Number:	D2282-7
Inspection Dwg: D2282 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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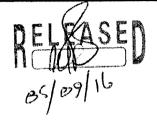
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.795	+/-0.010	.796	_			
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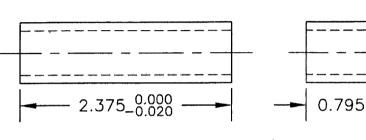
Measured by:	Audited by:	Prototype Approval:	N/A
Date: 09.07	Date: 06.09.06	Date:	N/A

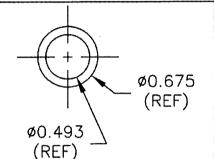
Rev	Date	Change		Revised by	Approved
Α	03.11.11	New Issue	P/O D350-615-041	KJ/RF	
В	05.04.19	0.795 was 0.750		KJ/JLM , ,	-1
С	06.03.15	Dwg Rev update		KJ/JLM o	911



DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECK	(ED/D	APPROVED	DRAWING NO. REV. E
	4	1/20	D2282 SHEET 1 OF 2
DATE			TITLE SCALE
05.0	6.07		HANDLE TUBES 1:1
Α		94.10.14	NEW ISSUE
В		95.03.23	RE-DESIGN
С		97.10.20	CORRECTED NUMBERING SCHEME
D		05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
Ε		05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030







SUMECT TO AMENDMEN

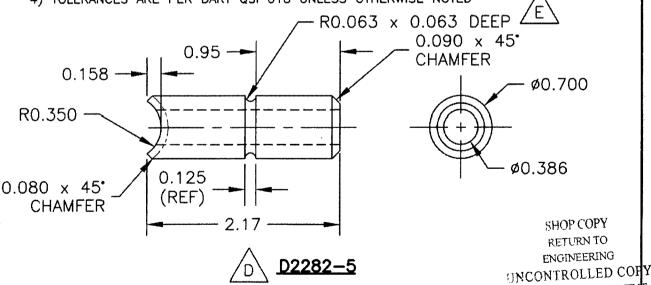
D2282-3



D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

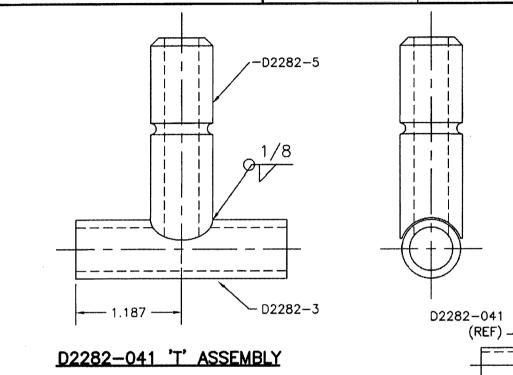
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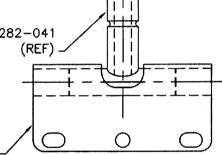
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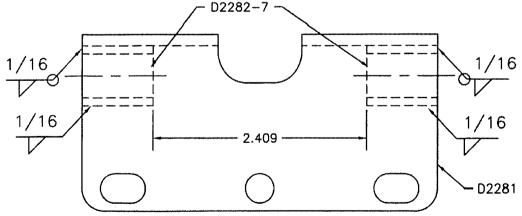
DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
l u'	1110	D2282	SHEET 2 OF 2	
DATE	100, -	TITLE	SCALE	
05.06.07		HANDLE TUBES	1:1	



WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY SCALE 1:2



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004

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D2282-043 (REF)

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